

Date: Tuesday, 12/20/2005 3:37:10 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: WEARPLATE
Job Number	: 25330		
Estimate Number	: 10315		
P.O. Number	: N/A	Part Number	: D265635
This Issue	: 12/20/2005 S.O. No. : N/A	Drawing Number	: D2656 REV D
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: 12/20/2005 Type : PURCHASED PARTS	Drawing Revision	: D
Previous Run	: 24148	Material	: N/A
Written By	: <u>SEE COMMENT BELOW</u>	Due Date	: 1/15/2006
Checked & Approved By	: <u>SEE ABOVE DATE & USER</u>	Qty:	50 Um: Each
Comment	: Est: D 02.10.25 Re-format KJ/RF		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description:
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1.0	PG	PURCHASING
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Comment: PURCHASING

Issue P/O: 319

1-Email or ship DXF file to vendor

2-Laser Cut per Dwg D2656 flat pattern D2656-35

3-Material release note required

W 50 05.12.21

2.0	D265635F	Wearplate
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 50.0000 Each(s)
 WEARPLATE

3.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Receive & Inspect for Transit Damage

Ensure Material Release Note is attached

C 2006/01/31 50

4.0	QC6	DIMENSIONAL CHECK
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Comment: DIMENSIONAL CHECK

Inspect dimensions per template D2656-35T1

J 06.02.02

5.0	BRAKE NC	NC BRAKE
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Comment: NC BRAKE

1-Deburr if necessary

2-Form on Brake as per Dwg D2656 using Jigs DT8261 and DT8326.

3-Identify as D2656-35.

SB 06/02/20

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: DD Date: 04/02/08
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPLATE

Job Number: 25330

Part Number: D265635

Job Number:



Seq. #: Machine Or Operation: Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Johnston

Comment: INSPECT WORK TO CURRENT STEP

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

Q. m 06-02-28

(50)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

mm

06 02 28

(50)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *F.P.*

mm

06 02 28

(50)

10.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

mm

06/02/28

(50)

Job Completion



mm 06-02-28

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

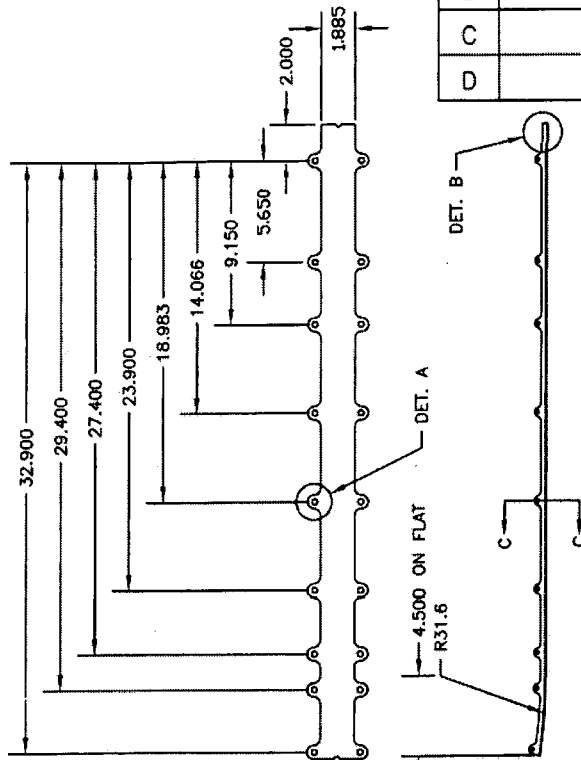
NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

NOTE: Date & initial all entries

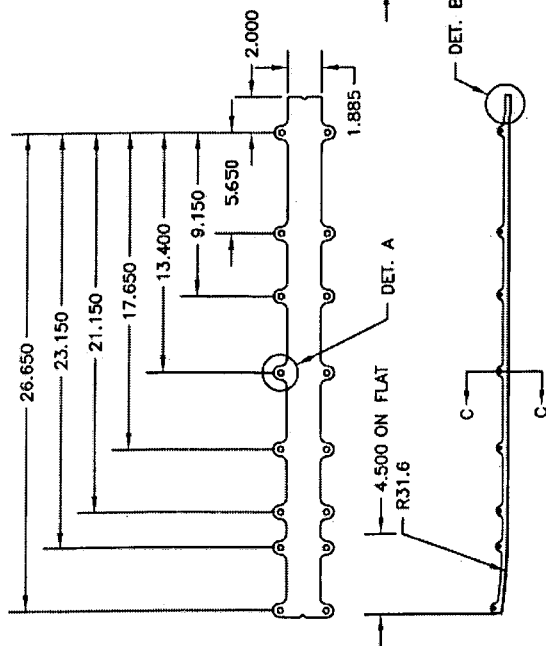


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				PORT HADLOCK, WA
CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	DRAWING NO. D2656
				REV. D SHEET 1 OF 4
DATE	05.08.17	TITLE	WEARSHOE	SCALE 1:10
A	97:03:25	NEW ISSUE		
B	97:06:02	CHANGED TABS		
C	97:06:26	R31.6 WAS R19.5		
D	05.08.17	ENLARGE ALL HOLES TO IMPROVE FIT		

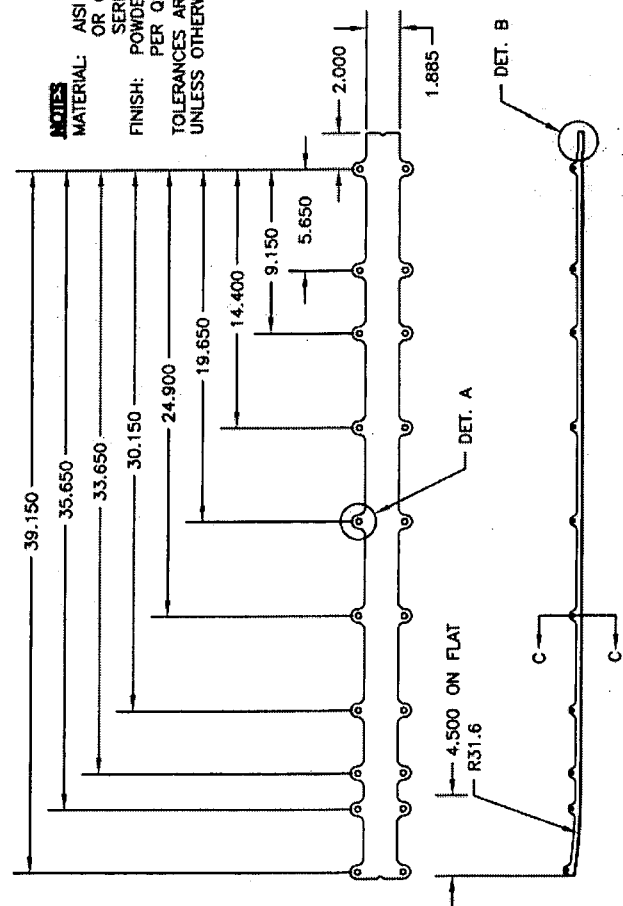
D2656-13



D2656-11



D2656-15



NOTES:
MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008
OR CSA G40-21, 38W/44W/50W/60W/70W
SERIES STEEL 20 GAUGE (0.040 THICK)
FINISH: POWDER COAT GREY SANITEX (4.3.5.6)
PER QSI 005 4.3
TOLERANCES ARE PER DART QSI 018
UNLESS OTHERWISE NOTED

RELEASED
05.09.08
HIFC
WITH

25330

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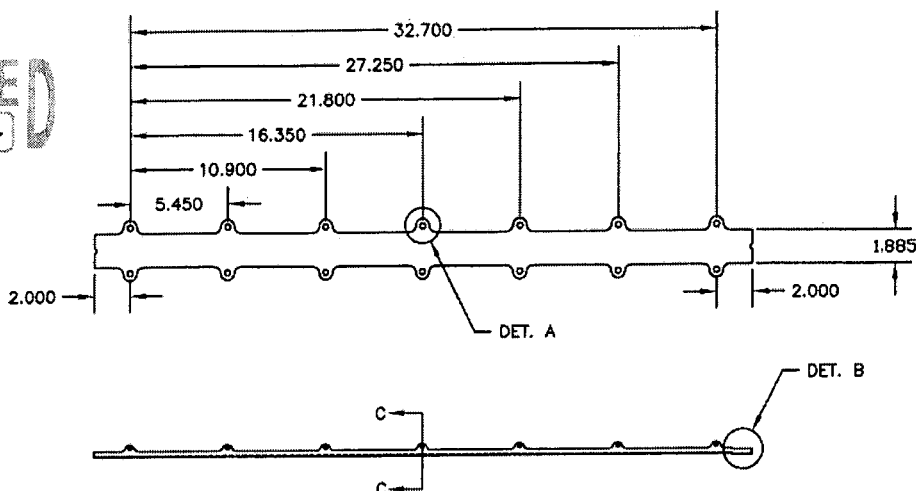
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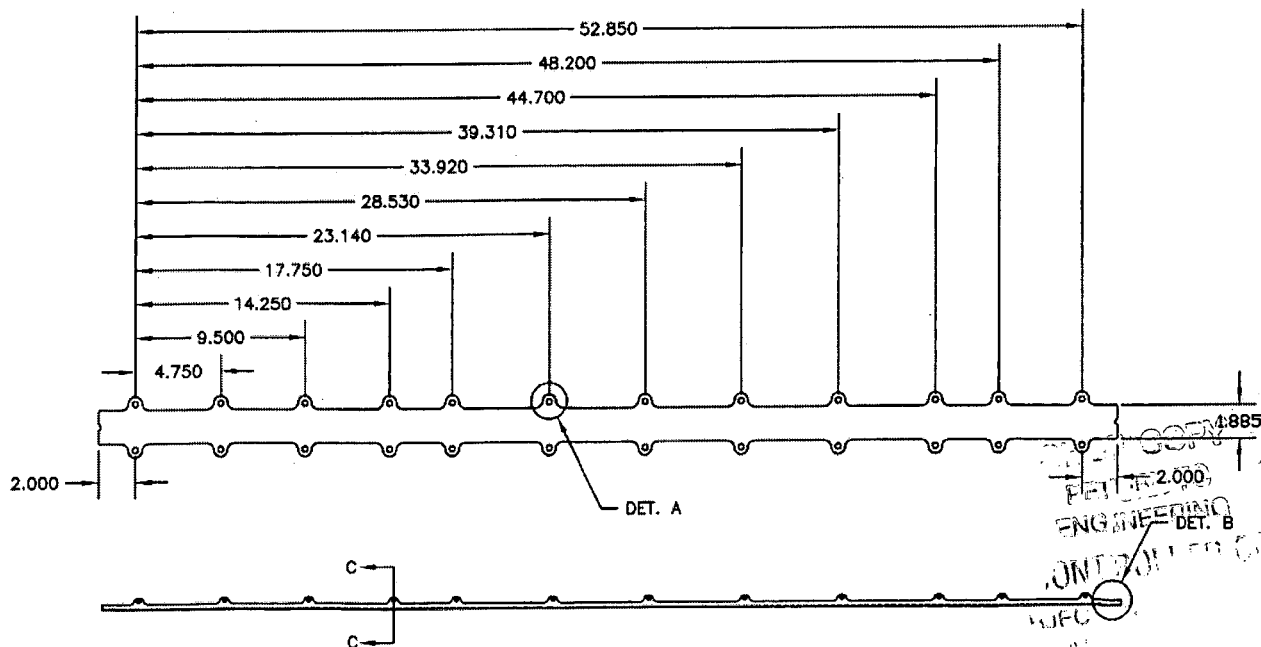
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CHECKED JA	APPROVED H	DRAWING NO. D2656	REV. D SHEET 2 OF 4
DATE 05.08.17	TITLE WEARSHOE		SCALE 1:10

RELEASED
DS-07-06

D2656-21



D2656-23



NOTES

MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W
SERIES STEEL, 20 GAUGE (0.040 THICK)
FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
TOLERANCES ARE PER DART QSI 018
UNLESS OTHERWISE NOTED

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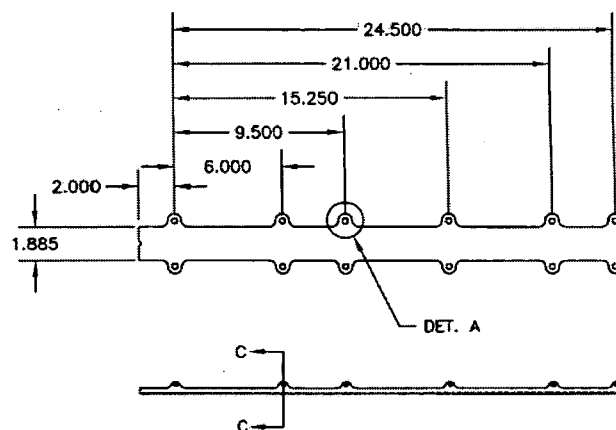
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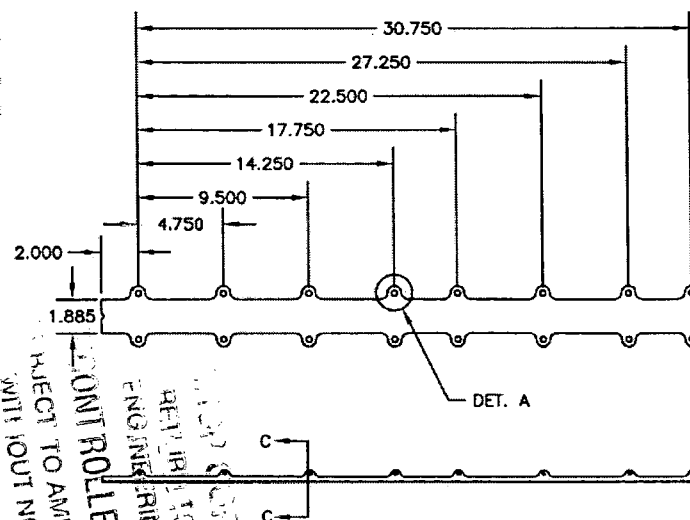


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DATE	05.08.17	TITLE	D2656	WEARSHOE
		REV. D	SHEET 3 OF 4	SCALE
				1:10

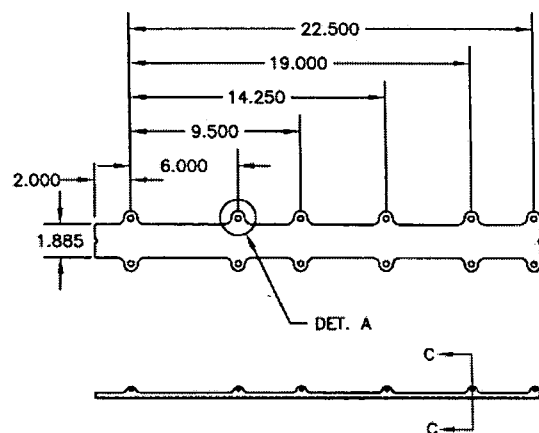
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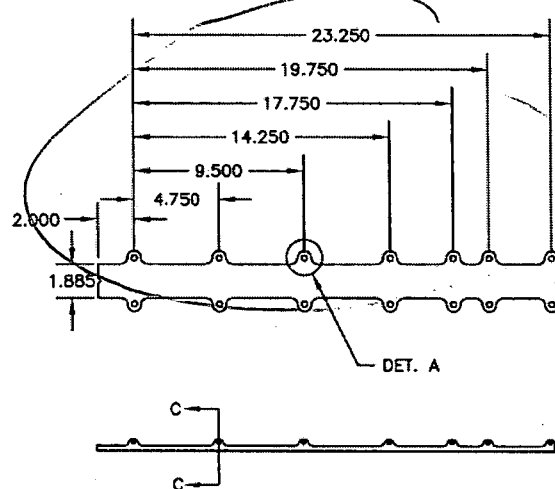
D2656-37



D2656-31



D2656-35



NOTES

MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W
SERIES STEEL, 20 GAUGE (0.040 THICK)
FINISH: POWDER COAT GREY SANTEX (4.3.5.6) PER QSI 005 4.3
TOLERANCES ARE PER DART QSI 018
UNLESS OTHERWISE NOTED

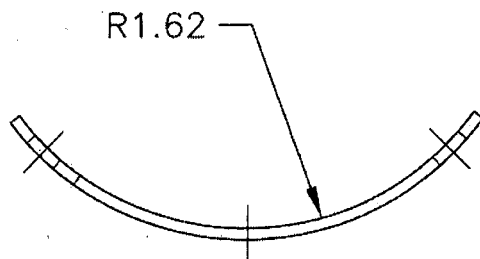
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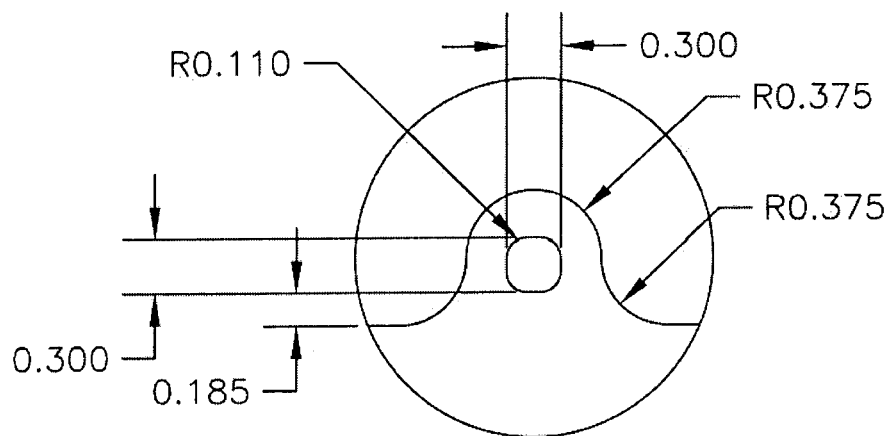
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DATE 05.08.17	TITLE WEARSHOE		SCALE 1:10

SECTION C-C

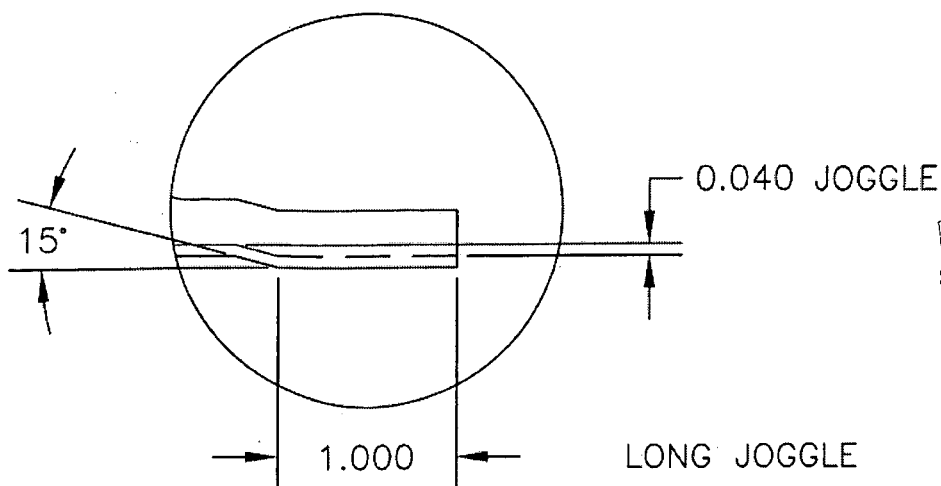


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05.09.06

DETAIL A



DETAIL B



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Postal: Private Bag 92121, Auckland, New Zealand
Telephones: (09) 375 8999 / 375 8111 Auckland
(09) 235 8069 / 235 3535 Waiuku
Fax: (09) 375 8959

TEST CERTIFICATE

Ref: 5135/22147

CUSTOMER	Wilkinson	P50224DI004	SPECIFICATION	ASTMA 1008 CS Type A	CERTIFICATE No	TC110913
CUSTOMER O/N	90-21N-597		PRODUCT	CRA WIDE COIL	PAGE	1 of 1
MILL O/N	475192		DIMENSIONS	0.033" x 48" x Coil	DATE	17 May 2005

		CHEMICAL COMPOSITION PERCENT															MECHANICAL TESTS (TEST SPECIFICATION - ASTM A370)							
PACK NUMBER	HEAT No	C	Si	Mn	P	S	Cu	Ni	Cr	Mo	V	Nb	Ti	Al	B	N2	CE ()	BEND	YIELD	T.S.	%ELONG	HARDNESS	r	LENGTH
		x100										x1000				x10000	x100	180°			GL =	HRB	()	(feet)
R9-458541-00	641012	5	TR	20	9	14	12	18	22	2	8	1	1					Good				52		2546
R9-458542-00	641012	5	TR	20	9	14	12	18	22	2	8	1	1					Good				52		2766
R9-458543-00	641012	5	TR	20	9	14	12	18	22	2	8	1	1					Good				53		2546
R9-458544-00	641012	5	TR	20	9	14	12	18	22	2	8	1	1					Good				53		2779
R9-458545-00	641012	5	TR	20	9	14	12	18	22	2	8	1	1					Good				51		2582
R9-458546-00	641012	5	TR	20	9	14	12	18	22	2	8	1	1					Good				51		2677
R9-458547-00	641013	5	TR	20	11	17	12	17	24	2	8	1	1					Good				51		2582
R9-458548-00	641013	5	TR	20	11	17	12	17	24	2	8	1	1					Good				51		2582

YIELD	GAUGE LENGTH (G.L.)				PLASTIC STRAIN RATIO (r)				IMPACT TEST				CARBON EQUIVALENT VALUE (CE)			
(A)=0.2% PROOF STRESS	(A)=200mm	(C)=80mm	(E)=2"		(A)=r0	(C)=45			(A)=5mm x 5mm				(A)=C+Mn/5			
(B)=LOWER YIELD STRESS	(B)=50mm	(D)=5.65 x So	(F)=8"		(B)=r90	(D)=(r0+r90+2r45)/4			(B)=10mm x 10mm	(C)=2.5mm x 10mm			(B)=C+Mn/6+(Cr+V+Mo)/5+(Cu+Ni)/15			(C)=C+Mn/6+Si/24
									(B)=7.5mm x 10mm	(E)=5mm x 10mm						(D)=

WE HEREBY CERTIFY THAT THE MATERIAL DESCRIBED HEREIN HAS BEEN TESTED AND INSPECTED
WITH SATISFACTORY RESULTS IN ACCORDANCE WITH THE REQUIREMENTS OF THE ABOVE SPECIFICATION

APPROVED

Satish Misra
QC METALLURGIST

